



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Ship March 28

D2435
Job Sheet 171557



Part No: D2435

Job Qty: 20 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/2/18

Job Tracking No:

Due Date: 2/12/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		2/9/18	0.00	0.00	Start Up Container		<i>on 18/03/18</i>
120	Waterjet	20 pcs		2/9/18	0.00	3.72	Waterjet1		<i>on 18/03/18</i>
130	CNC Vertical Machining	20 pcs		2/12/18	0.41	20.28	HAAS 1		<i>done 18/03/18</i>
150	QC	20 pcs		2/12/18	0.00	0.00	QC8		<i>18-03-29</i>
151	Packaging	20 pcs		2/12/18	0.00	0.00	Packaging3 <i>shu</i>		MAR 29 2018
190	QC21-SA	20 Ea		2/12/18	0.00	0.00	QC21		MAR 29 2018

Part Op 120 - CUT BLANK AS PER FILE D2435

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	64 sf (3.2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	64	1,943	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053		
2	Bearpaw	45.000Degrees ± 0.030	45.030 44.970	Angle	
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470		
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170		
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220		
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595		
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240		
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	Angle	
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365		
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970		
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940		
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	Diameter	
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	Diameter	
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300		
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345		
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345		
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240		
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970		
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990		
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720		

Plex 3/16/18 11:48 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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